

Work Order ID 50311

July 14, 2009 11:55:06 AM

Page 1

Item ID: D3514-043

Accept

Setup Start

Revision ID: A

Stop

Item Name: Top Mounted Gimbal Assembly

Start Date: 7/15/09 Start Qty: 2.00

Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty -

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3514

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3514

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Identify as per dwg & Stock Location:

Packaging

Memo

0.00

Packaging

9/5/09/12/11 (2)

=> 8/2/12/11

(+2)

9/12/14 (2x) sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50311

July 14, 2009 11:55:06 AM



Page 2

Item ID: D3514-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Mounted Gimbal Assembly

Start Date: 7/15/09 Start Qty: 2:00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.12.16

MF 09-12-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

July 14, 2009 11:55:06 AM

Work Order ID: 50311

Parent Item: D3514-043RevA

Parent Item Name: Top Mounted Gimbal Assembly







Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-6A  Bolt		Purchased	No			100	Each	103.0000	2.0000 		09/12/11 1112720 (24)	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST 103</div> <div>106662 22</div> <div>107959 15</div> <div>109752 29</div> <div>112082 37</div>												
AN960JD10L  Washer		Purchased	No			100	Each	7,153.000	4.0000 		09/12/11	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST 7237</div> <div>101291 16</div> <div>104885 153</div> <div>105793 236</div> <div>109632 1832</div> <div>110985 5000</div> <div>Main Warehouse</div> <div>ST182 -84</div> <div>109632 -84</div>												
D3514-047RevA  Top Mounted Housing Assembly		Manufactured	No			100	Each	0.0000	2.0000 		09/12/11	

B50308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

July 14, 2009 11:55:06 AM

Work Order ID: 50311

Parent Item: D3514-043RevA

Parent Item Name: Top Mounted Gimbal Assembly









Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3522-1RevA  Gasket		Manufactured	No			100	Each	13.0000	2.0000 		8/5/09/12/11	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>35370</div>												
<div>Loc Qty</div> <div>13</div> <div>13</div>												
<div>Loc Code</div> <div>2</div>												
D3523-3RevB  Leg		Manufactured	No			100	Each	6.0000	2.0000 		8/5/09/12/11	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>35752</div>												
<div>Loc Qty</div> <div>6</div> <div>6</div>												
<div>Loc Code</div> <div>2</div>												
D3524-1RevA  Lower Plate		Manufactured	No			100	Each	6.0000	2.0000 		8/5/09/12/11	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>34802</div>												
<div>Loc Qty</div> <div>6</div> <div>52069</div>												
<div>Loc Code</div> <div>2</div>												
D3531-041RevA  Bracket Assembly		Manufactured	No			100	Each	0.0000	2.0000 		8/5/09/12/11	
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>352381</div>												
<div>Loc Qty</div> <div>6</div> <div>20</div>												
<div>Loc Code</div> <div>2</div>												

July 14, 2009 11:55:06 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 3

July 14, 2009 11:55:06 AM

Work Order ID: 50311

Parent Item: D3514-043RevA

Parent Item Name: Top Mounted Gimbal Assembly

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3533-3RevB

Manufactured

No

100

Each

176.0000

4.0000



Set Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

176

34899

78

35024

98

MS24693-S29

Purchased

No

100

Each

208.0000

8.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

208

103915

208

EP 509/12/11

EP 509/12/11

8

July 14, 2009 11:55:06 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

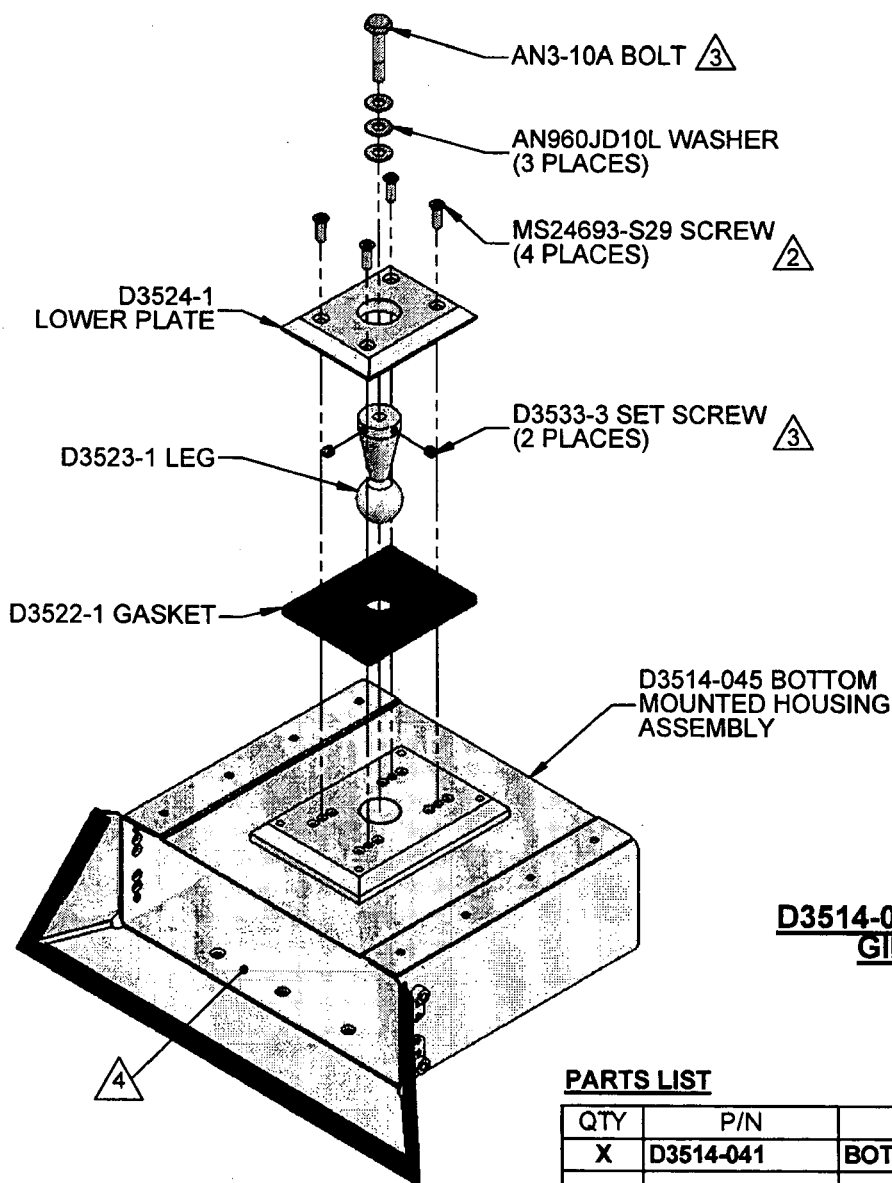
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514 REV. A SHEET 1 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE



RELEASED
07.08.07

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

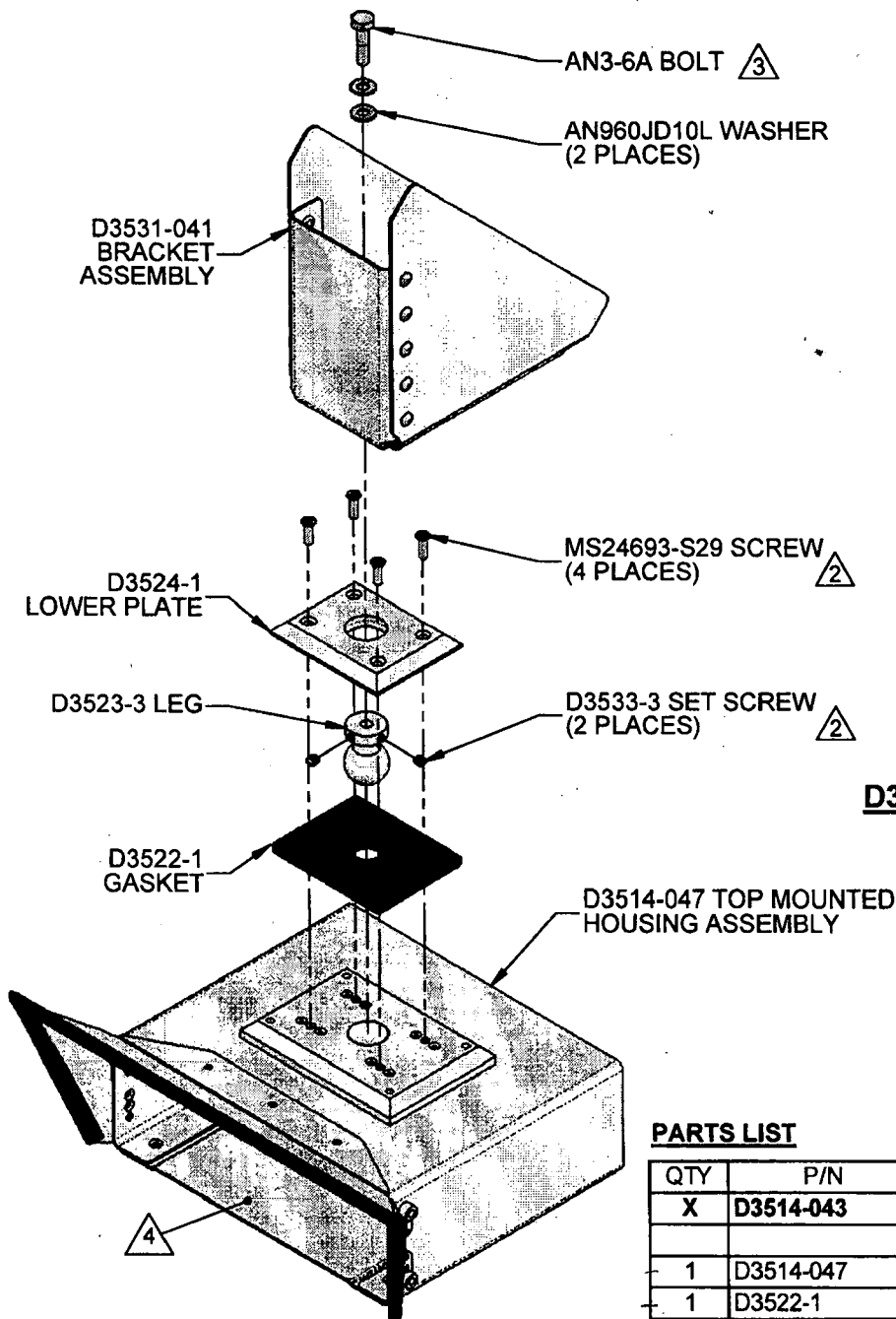
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 2 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING SCALE 1:3		



RELEASED
07.08.03

**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

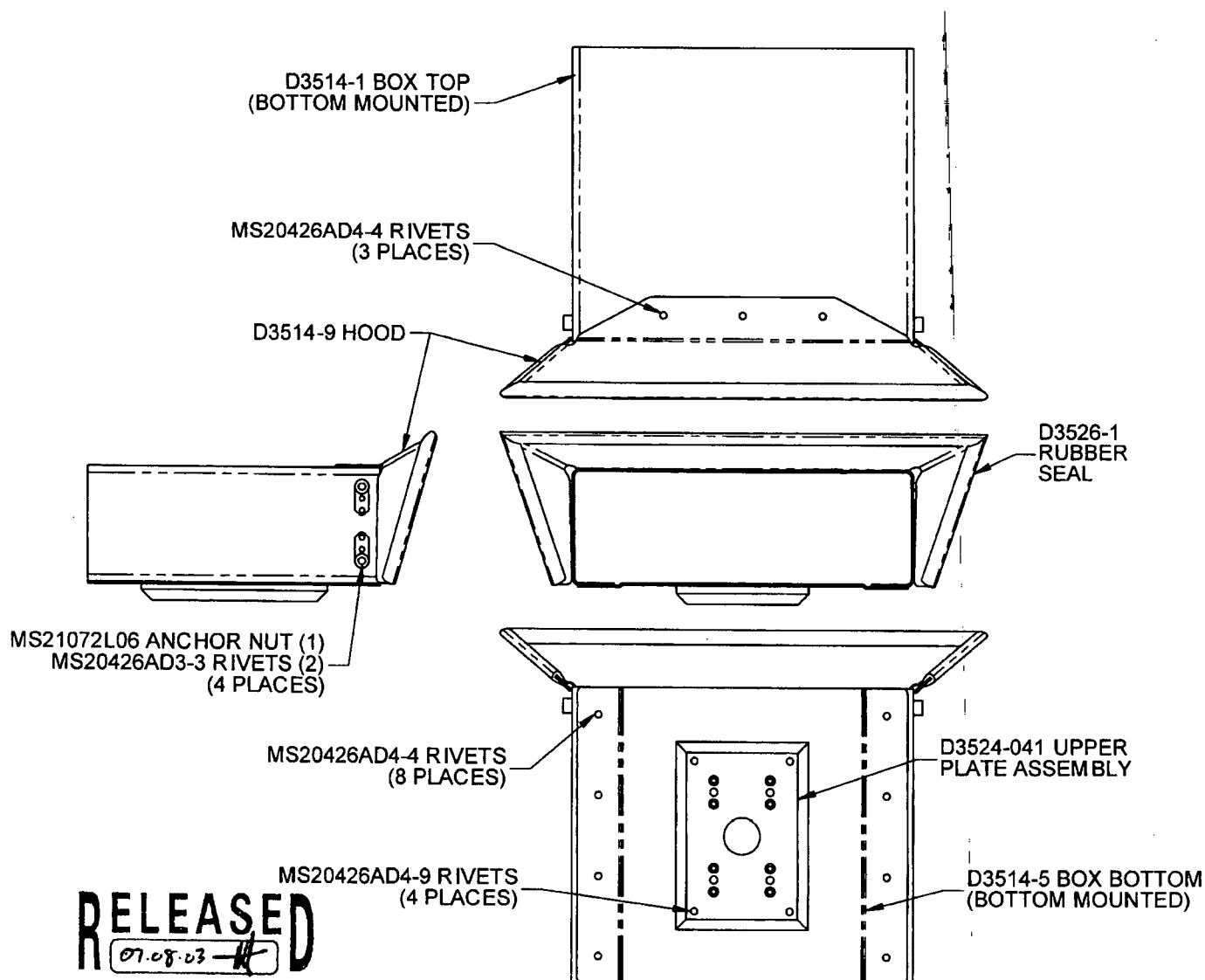
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 3 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



RELEASED
07.08.03 **[Signature]**

**D3514-045 BOTTOM MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

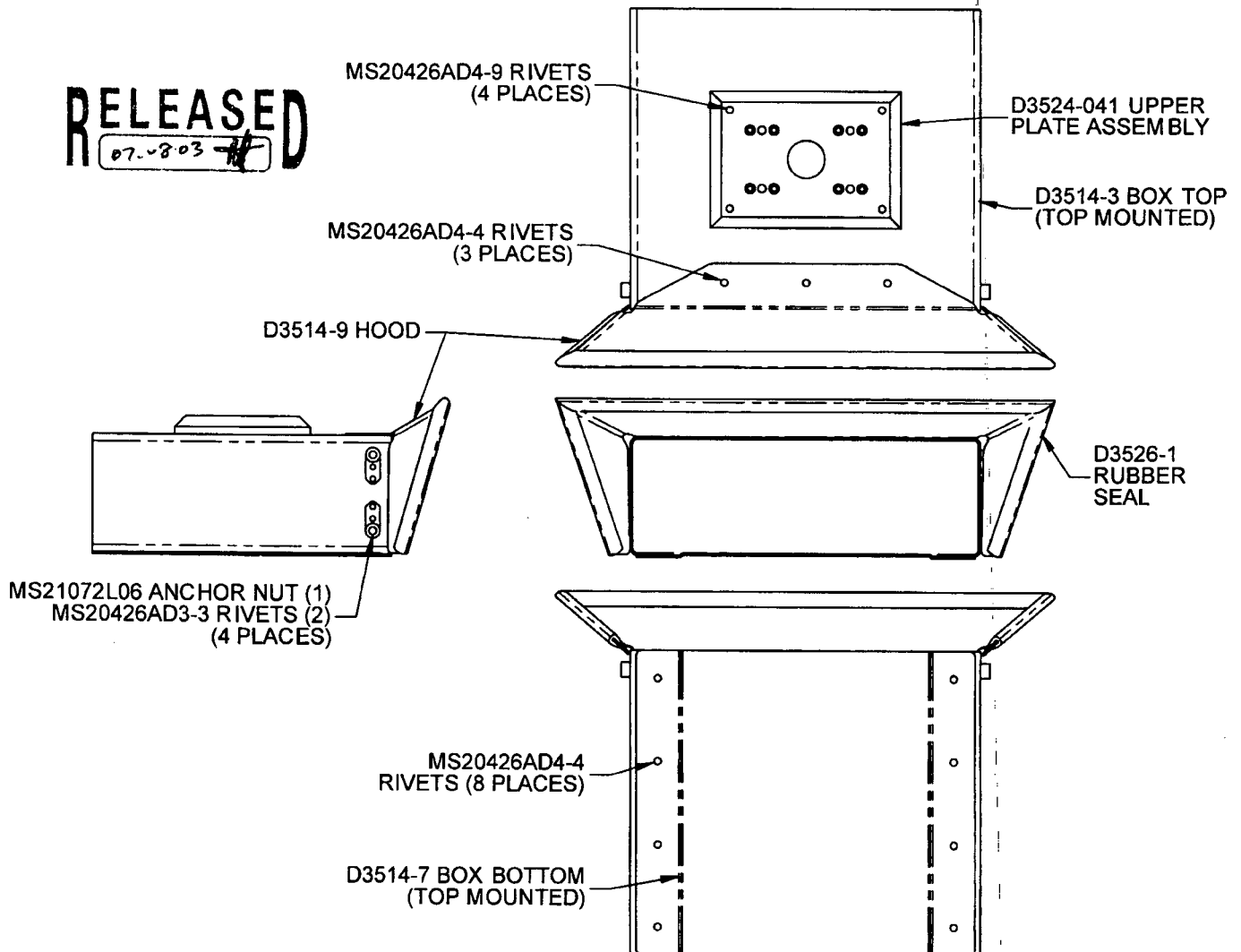
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3514	REV. A SHEET 4 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

RELEASED
07-803-#**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RVET
11	MS20426AD4-4	RVET
4	MS20426AD4-9	RVET
4	MS21072L06	ANCHOR NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

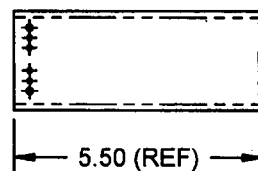
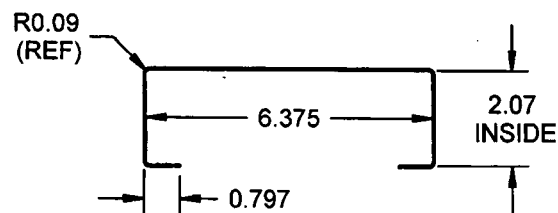
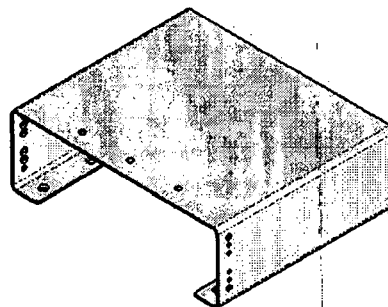
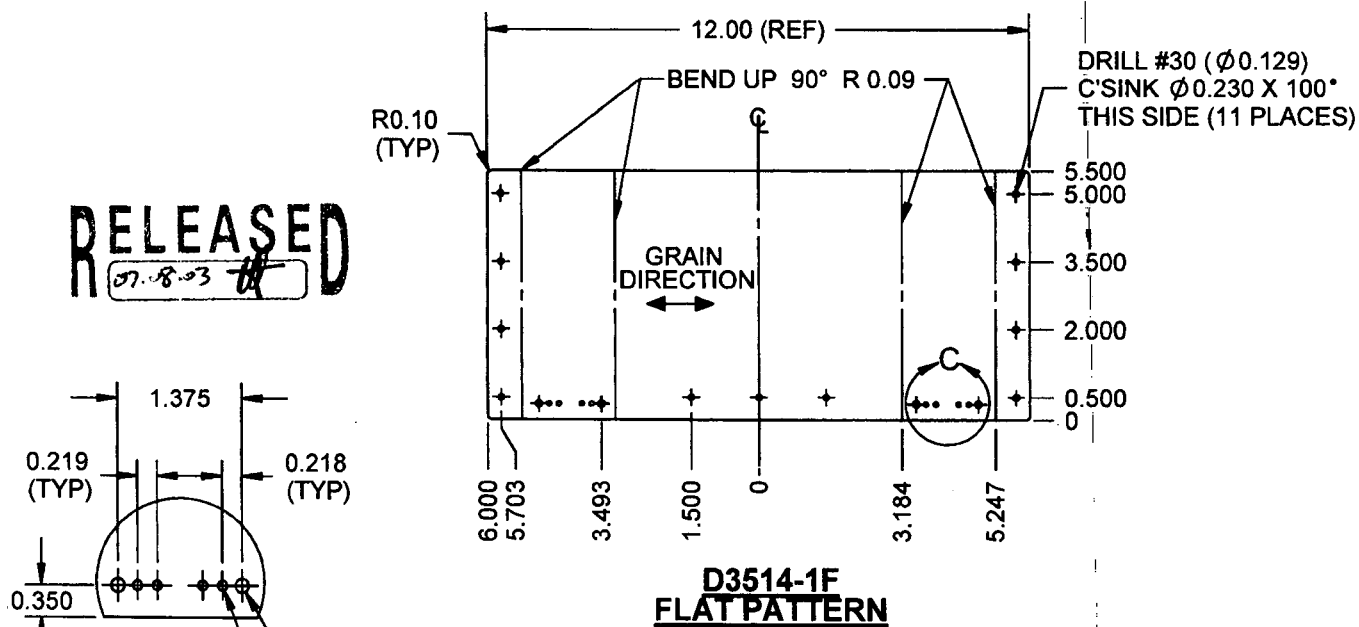
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 5 OF 9 SCALE 1:4

RELEASED
07.08.03 **[Signature]**



NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

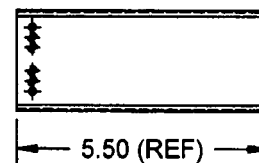
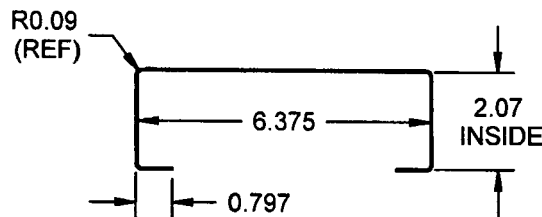
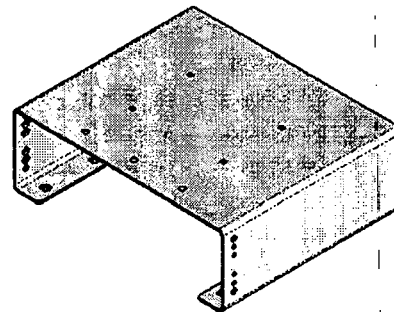
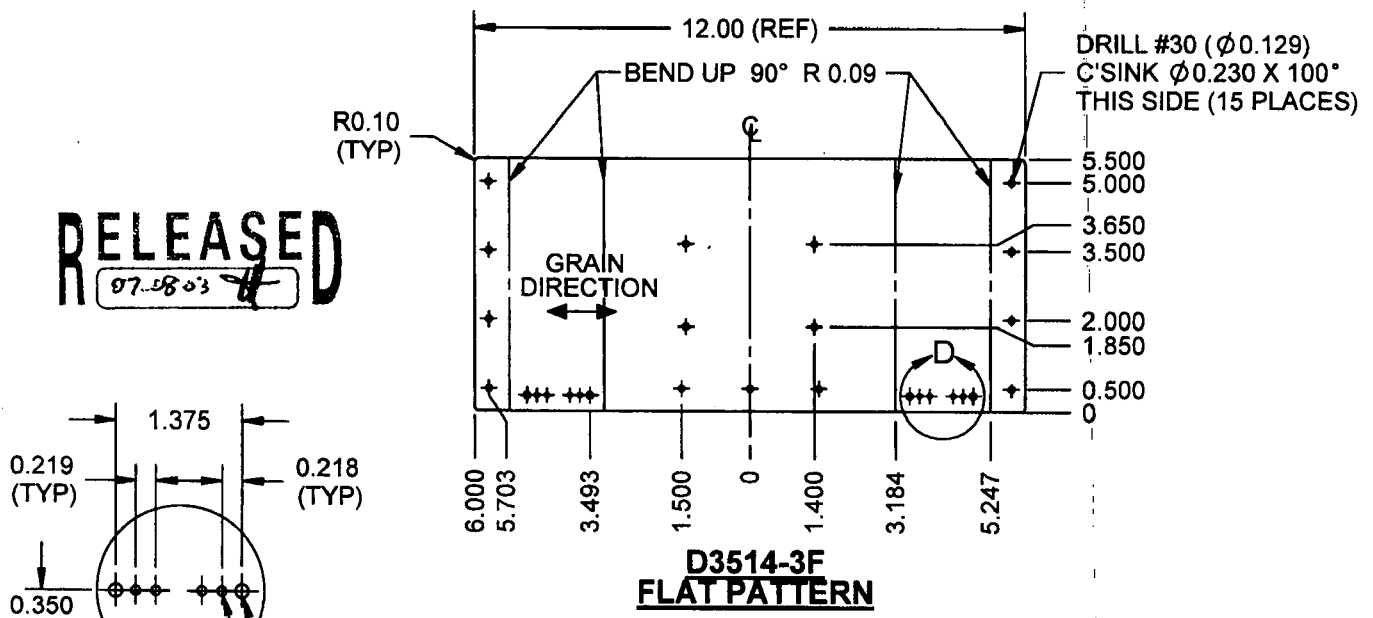
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NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 6 OF 9 SCALE 1:4

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

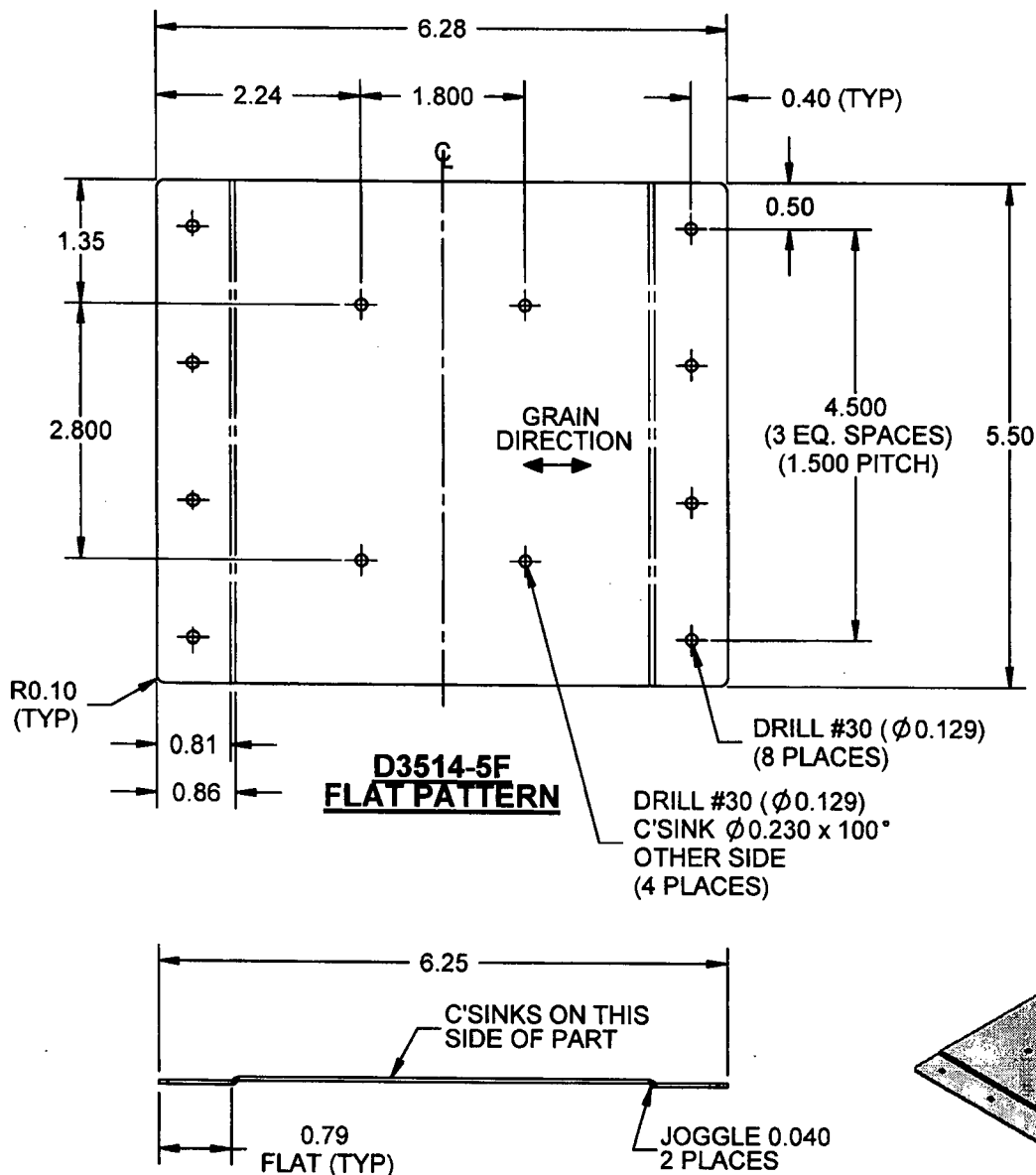
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 7 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING SCALE 1:2		

**D3514-5 BOX BOTTOM (BOTTOM MOUNTED)****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT \bar{C}
- 7) C'SINK ABOVE JOGGLE

RELEASED
07.08.03 **[Signature]**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

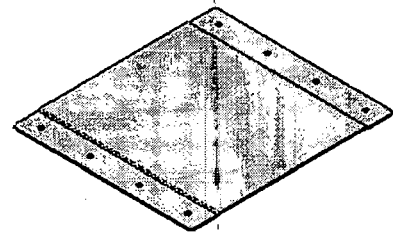
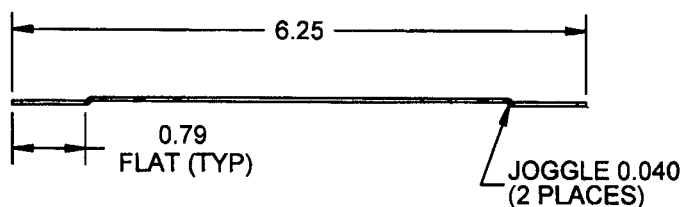
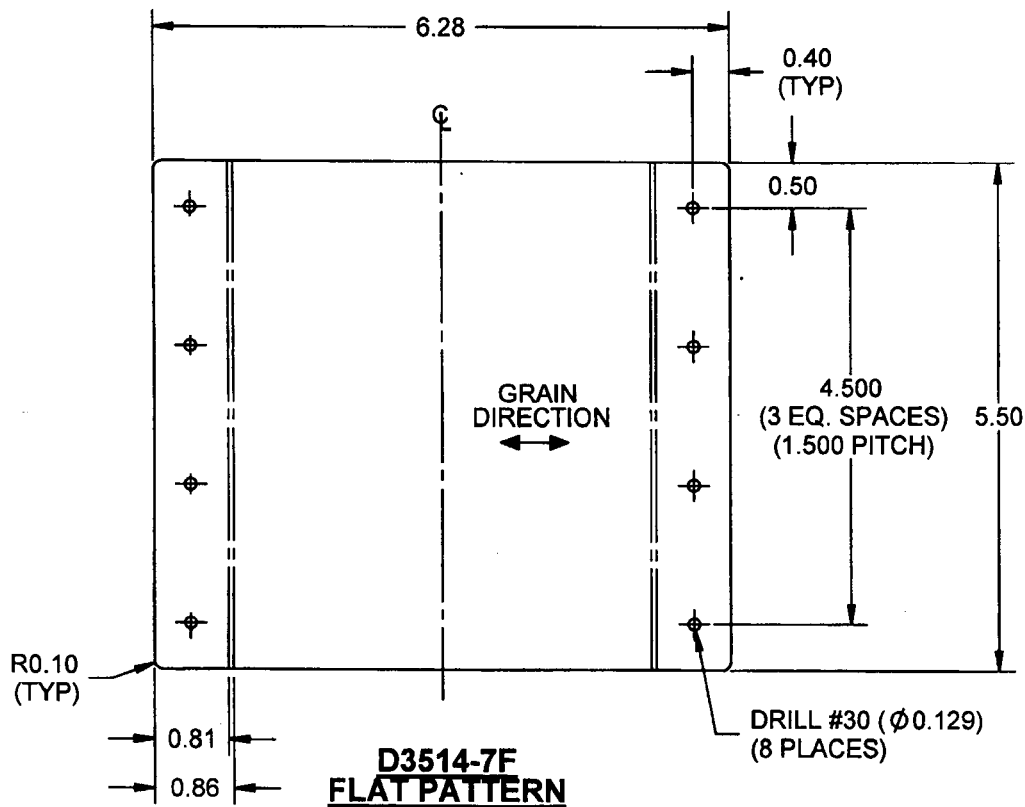
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 8 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:2

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

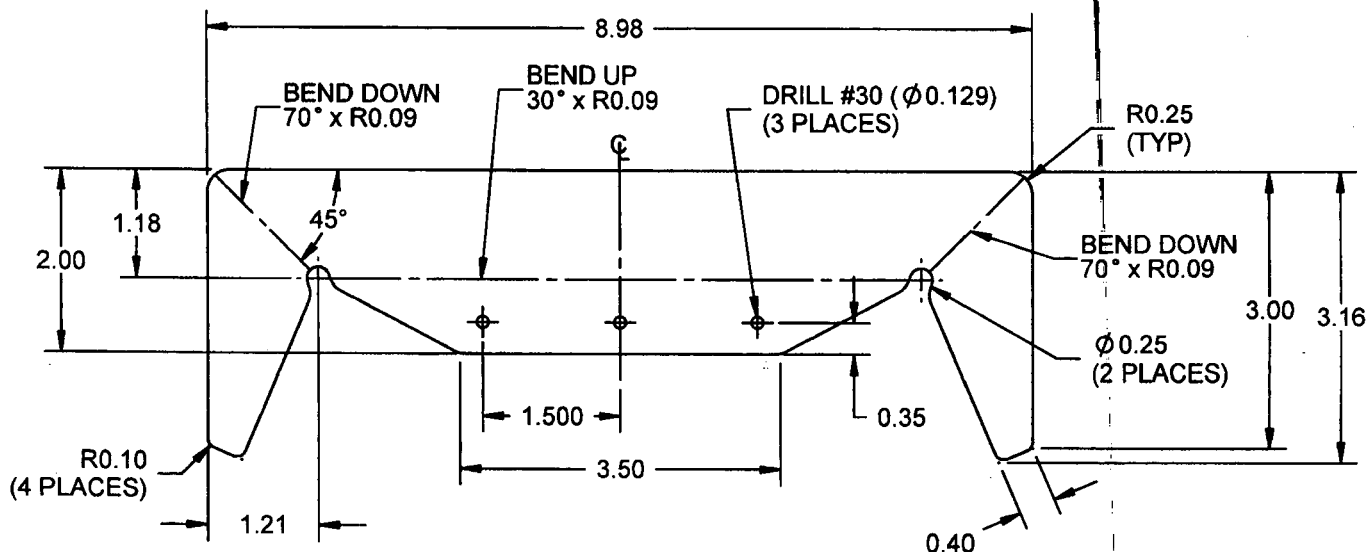
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

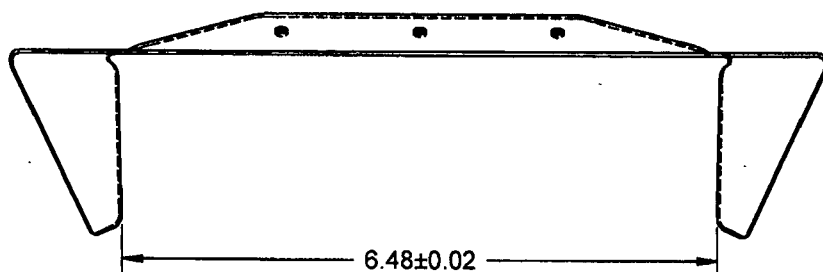
NOTE: Date & initial all entries

DART

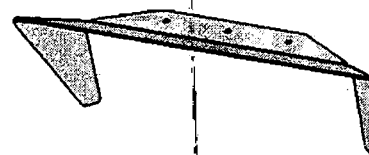
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING SCALE 1:2		



D3514-9F
FLAT PATTERN



FRONT VIEW



RELEASED
07.08.03 **[Signature]**

D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries